

Work Order ID 62833

Friday, October 08, 2010 12:49:51 PM



Page 1

Item ID:	D3290-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Replacement Window Assembly					
Start Date:	10/8/2010	Start Qty:	6.00			
Required Date:	10/15/2010	Req'd Qty:	6.00			
Reference:						

Approvals:	Process Plan:		Date:	10-10-8	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3290	DEO Rev C1								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3290 (use prog. for D3290-1)								
6061 .063	Dwg Rev: C1								
	Prog Rev: C1								
	2-Deburr if necessary								

B 10-10-13

(6)

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

B 10-10-13

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

8/10/10/14

(76)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Approvals:	Process Plan:	Date:	Tooling:	Date:
	QC:	Date:	SPC (Y/N):	Date:

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	BR 10-10-15.			6			
140 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M 115291 Memo START TIME 10:25 OVEN TEMPERATURE 320° FINISH TIME 10:55	0.00 0.00	BR 10-10-19			6			
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	79H 10/10/19			6	φ		

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Friday, October 08, 2010 12:49:51 PM

Page 4

Item ID: D3290-041

Accept

Revision ID:

Item Name: Replacement Window Assembly

Start Date: 10/8/2010 Start Qty: 6.00

Required Date: 10/15/2010 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/12/09
MF
10-12-08

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NOTE: Date & initial all entries

Picklist Print

Friday, October 08, 2010 12:49:55 PM

Page 1

Work Order ID: 62833

Parent Item: D3290-041

Parent Item Name: Replacement Window Assembly




Start Date: 10/8/2010

Required Date: 10/15/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP B05.05.25 Added Step 11 KJ/JLM
 IPP C06.05.09 Ecn 798 EC
 IPP Rev:D Now on Waterjet 06-06-16 JLM
 IPP rev E rev C dwg 07.09.28 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063  6061-T6 .063 Sheet		Purchased	No			100	sf	80.2840	3.75	23.68421			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT21	113608	80.284							
					113608	80.284							
D2126  Seal		Manufactured	No			160	f	242.6234	6.5	39			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST405		242.6234211							
					48285	22.0884211							
					57106	220.535							
(D2126-0780) cut qty (1) at 78.00" as per dwg ***per kit***													
D3290-3  Window		Manufactured	No			160	Each	13.0000	1	6			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST221		13							
					57837	4							
					58726	9							

1810-10-13

(6)

~~113608~~
113608

SAD 10-12-08

39

SAD 10-12-08

2
4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 62833
Description: Window Frame		Part Number: D3290-1
Inspection Dwg: D3290	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
29.00	+/-0.030	29.00	X		T B01	
14.00	+/-0.030	14.00	>		T	
Ø0.171	+0.005/-0.001	.175	A		V B02	
1.50	+/-0.030	1.503	*		V	
1.11	+/-0.030	1.109	x		V	
10.10	+/-0.030	10.10	X		T	
18.50	+/-0.030	18.50	*		T	
0.063	+/-0.010	.063	x		V	
R3.00	+/-0.030	3.00	*		R.G.	
R4.50	+/-0.030	4.50	*		R.G.	
Ø0.257	+0.006/-0.001	.262	*		V	
13.61	+/-0.030	13.61	X		T	

Measured by: B	Audited by: S.	Prototype Approval:	N/A
Date: 10-10-13	Date: 10/10/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.19	New Issue P/O D3290-041	KJ/JLM	
B	07.07.18	13.61 dimension removed	KJ/JLM	
C	07.09.28	Dimensions update per Dwg Rev C	KJ/EC/DD	
D	09.11.04	Dimension 0.063 was 0.040	KJ	

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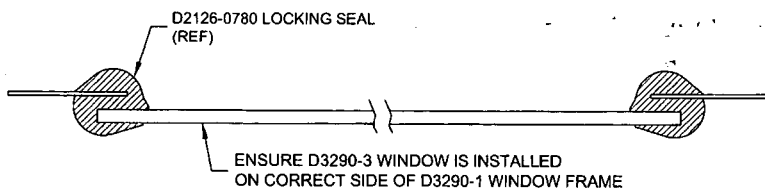
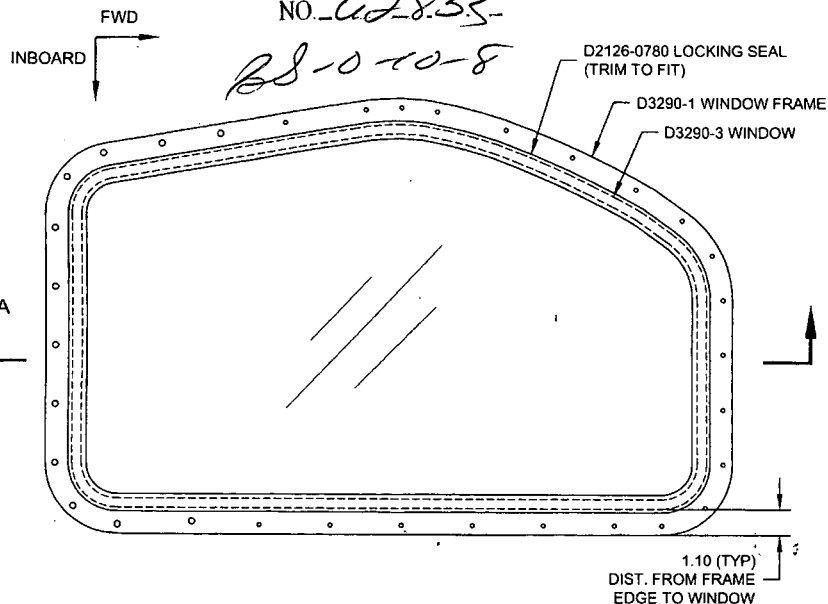
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NOTE: Date & initial all entries

STANDARD
DRAWING
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO CHANGE

WIL
WIL
NO. *62833*
BS-010-8



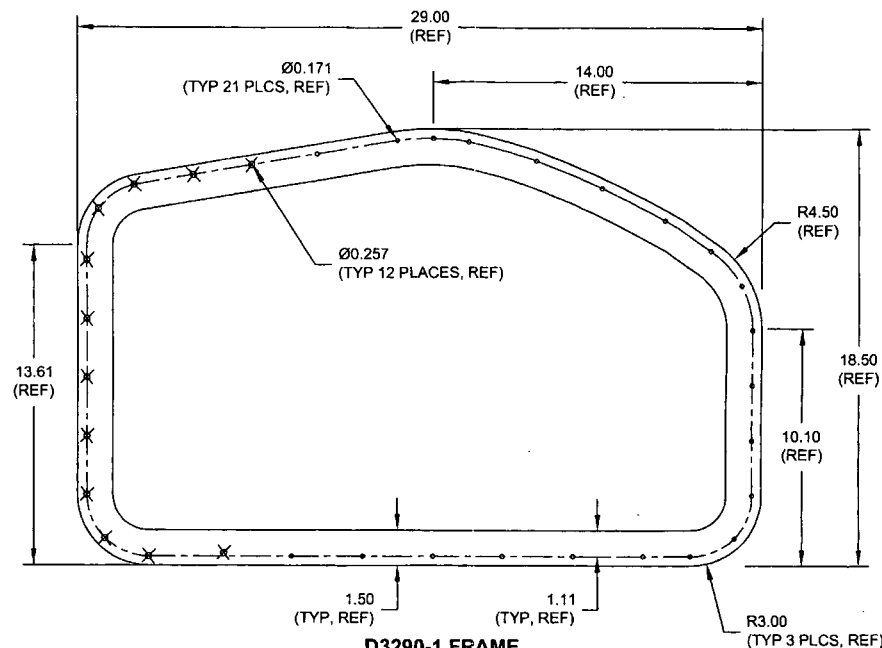
SECTION A-A
NTS

D3290-041 REPLACEMENT WINDOW ASSEMBLY

D3290-041 NOTES:
1) WEIGHT: 3.66 LBS

GENERAL NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED



D3290-1 FRAME

D3290-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.040)
OR
5052-H32 ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/8 OR AMS 4016
(REF. DART SPEC. M5052H32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
- 3) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 4) IDENTIFICATION: IDENTIFY WITH DART P/N "D3290-1" USING FINE POINT PERMANENT INK MARKER
- 5) WEIGHT: 0.47 LBS

RELEASED
07.07.24
DEO ATTACHED

C	UPDATE DIMS PER PAR 188	DC	07.07.24
B	UPDATE MATERIAL PER NCR 029	MB	06.04.20
A	NEW ISSUE	RF	04.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.07.24		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3290
REV. C
SHEET 1 OF 2

TITLE
REPLACEMENT WINDOW ASSEMBLY
SCALE
1:5

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UNDER REVIEW

4/07.07.18
7/18 07-05
6/1/17/19

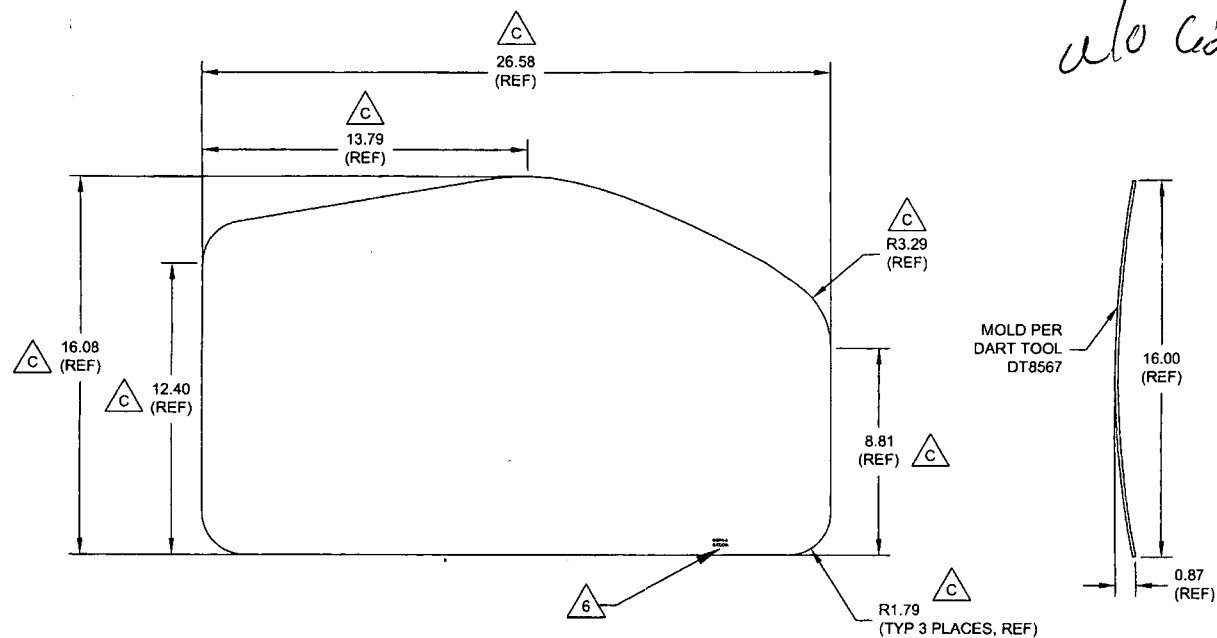
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NOTE: Date & initial all entries



D3290-3 WINDOW

D3290-3 NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER
LP-391 TYPE 1 GRADE C, 0.125 THICK
(REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 +/- 0.42 LBS
- 8) MOLD PER DART TOOL DT8567

UNDER REVIEW

DEO ATTACHED
RELEASED
07.07.22

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3290	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		REPLACEMENT WINDOW ASSEMBLY 1:5	
DATE	07.07.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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DRAWING NO. D3290	TITLE REPLACEMENT WINDOW ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3290-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>QD</i>	CHECKED <i>JS</i>	MFG. APPR. <i>EZ</i>	APPROVED <i>MD</i>		DE APPR. <i>##</i>		
DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09/09/21		DATE 09/09/21		

PURPOSE:

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

W/O 62833

D3290-1 NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)
 OR
 5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/8 OR AMS 4016
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

RELEASED
 2009 -10- 09
MD

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